

Date: Wednesday, 06/08/2008 9:20:01 AM
 User: Julie Lecocq

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HELI-ACCESS STEP RH (FOLDING)		
Job Number	: 40998- <u>24</u>			Part Number	: D412630034		
Estimate Number	: 12568			Drawing Number	: IIN D412-630		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/08/2008 S.O. No. :			Drawing Revision	: L		
Prsh Rev.	: NC			Material	:		
First Issue	: 06/08/2008 Type : LARGE FAB ASSY			Due Date	: 28/08/2008 Qty: <u>5</u> Um: Each		
Previous Run	: 40269						
Written By	:						
Checked & Approved By	: <u>JUL 08-S 06</u>						
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG003			
<i>S ocket</i>			
2.0	D2012107	Clevis	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch			
	1 D2012-107	Clevis	<u>40274</u> <u>AS 08/08/07</u>
3.0	D2803042	Bracket Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch			
<i>-3 ordered</i>	1 D2803-042	Bracket Assembly RH	<u>34017x2</u> <u>AS 08/08/07</u>
4.0	D2804042	Bracket Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch			
	1 D2804-042	Bracket Assembly RH	<u>35827</u> <u>AS 08/08/07</u>

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- Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2807041 Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Batch:

35751



AS 08/08/07 (X5)

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	34020

Batch

34020



AS 08/08/07 (X5)

7.0 D3562042 Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-042	Step Weldment RH	B41246

Batch

B41246



EB 08/09/07 (2)

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	33578 X14

Batch

33578 X14



AS 08/08/07 (X5)

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	101189

Batch

101189



AS 08/08/07 (X5)

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	AN8C16	Bolt
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 2 AN8C16 Bolt <u>106264</u> <i>AS 08/08/07 (FS)</i>
11.0	AN310C8	Nut
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Nut Pick: Qty Part Number Description Batch 2 AN310C8 Nut <u>M166431</u> <i>AS 08/08/07 (FS)</i>
12.0	MS24665302	Cotter Pin
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Cotter Pin Pick: Qty Part Number Description Batch 2 MS24665-302 Cotter Pin (or AN380C3-4) <u>M166763</u> <i>AS 08/08/07 (FS)</i>
13.0	NAS1515H3	Washer
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s) Washer Pick: Qty Part Number Description Batch 6 NAS1515H3 Washer <u>M1C761</u> <i>AS 08/08/07 (FS)</i>
14.0	NAS1515H5L	WASHER
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) WASHER Pick: Qty Part Number Description Batch 4 NAS1515H5L Washer <u>M108964 (3x)</u> <i>AS 08/08/07 (FS)</i>

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*Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M106575

AS 08/08/07 (X3)

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108673

AS 08/08/07 (X5)

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101340

AS 08/08/07 (X5)

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M104251

Epoxy 08/08/07 (2)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soil test R210

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description Batch

2 D2806-1 Bushing

35630

AS 08/08/02 (x2)

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description Batch

2 D2806-3 Bushing

34019

AS 08/09/02 (x2)

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number Description Batch

1 D2810-5 Strut

36521+1
41029 x1

AS 08/08/02 (x2)

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number Description Batch

2 D3396-1 Spacer

34025

AS 08/09/02 (x2)

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4C6A Bolt

M10724A

AS 08/09/02 (x2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1	AN4C6A	Bolt	
26.0	AN4C10A	Bolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch M101189		AS 08/09/02 (R)
27.0	AN4C15A	Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch M107082		AS 08/09/02 (R)
28.0	AN44C7A	Eyebolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Eyebolt Pick: Packing Kit Qty Part Number Description Batch M100446		AS 08/09/02 (R)
29.0	AN5C15A	Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch M105125	Adjust QTY's I took toward out forgot about split	AS 08/09/02 (R)
30.0	NAS1515H4	Washer	
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch M108558		AS 08/09/02 (R)

Process Sheet

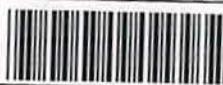
Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

- Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number
7 NAS1515H5

Description
Washer

Batch

M108334



AS 08/09/02 (R)

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number
4 MS21043-4

Description
Nut

Batch

M108672



AS 08/09/02 (R)

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number
3 MS21043-5

Description
Nut

Batch

M108583



AS 08/09/02 (R)

34.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: _____

PPP Rev: _____

S 08/09/02 (R)



AS 08/09/02 (R)

36.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/09/02 (R)

Job Completion



u 08-09-02

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

SHOP COPY

RETURN TO

ENGINEERING

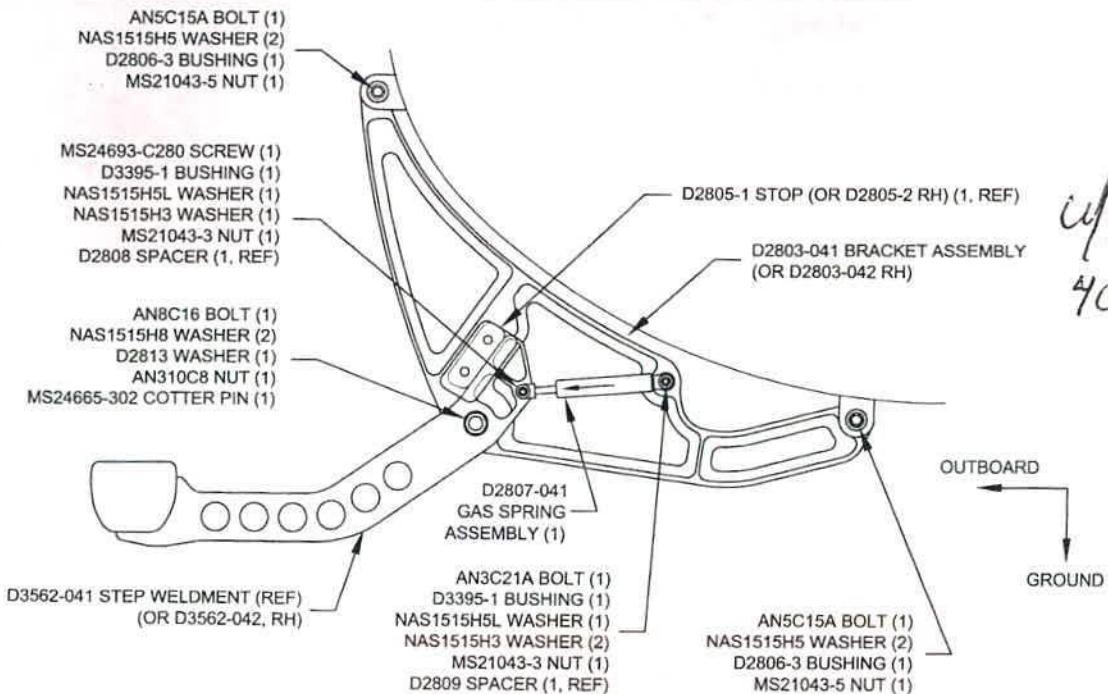
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

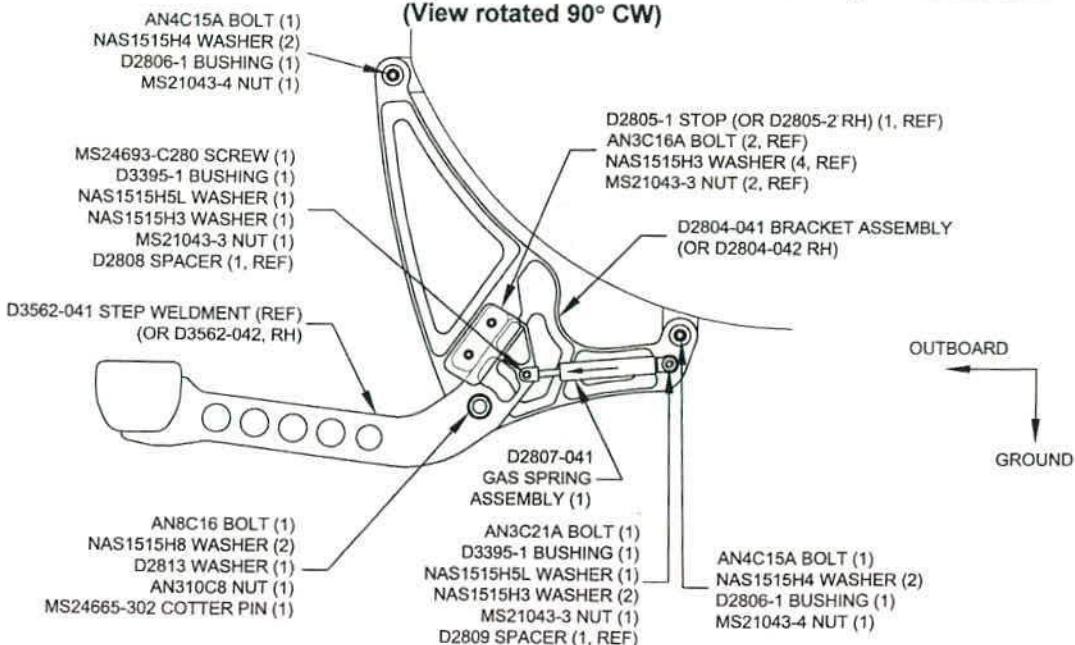
WITHOUT NOTICE

WORK ORDER

NO. 40948

D412-630-033/-034 Heli-Access-Step™ Installation

**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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